

Date: Friday, 5/30/2008 8:39:30 AM  
 User: David Duval

## Process Sheet

ok

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: BACK LEG ASSEMBLY
Job Number	: 05011		
Estimate Number	: 13323		
P.O. Number	:	Part Number	: D3782045
This Issue	: 5/30/2008 S.O. No. :	Drawing Number	: PROTO 01.05.30
Prsht Rev.	: NC	Project Number	: IA0004
First Issue	: 11	Drawing Revision	: PROTO
Previous Run	:	Material	:
Written By	: <u>08/05/30</u>	Due Date	: 6/6/2008
Checked & Approved By	:	Qty:	2 PA 01.05.02
Comment	: Est Rev:A 08-05-19 new issue DD verified by:ec	Um:	Each

Additional Product

PROTOTYPE

Job Number:



FOR ENGINEERING USE ONLY

Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
 Pick Packing Kit

2.0 D37721 Back Leg



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Back Leg  
 batch: B38888

080530 (4) PA 01.05.02

3.0 D37871 Foot



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Foot  
 batch: B39397

080530 (4) PA 01.05.02

4.0 D37641 Back Leg Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Back Leg Fitting  
 batch: B39109

080530 (4) PA 01.05.02

5.0 D3773041 Headrest Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Headrest Assembly  
 batch: B05004

080530 (4) PA 01.05.02

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Seq. #: Machine Or Operation: Description :

6.0 AN515A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

batch: M108077

AA

080530

(4) x 2  
(4)

Ref  
06.05.20

7.0 AN45 15A EYE BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

EYE BOLT

batch: M107938

AA

080530

(4) (2)

8.0 AN517A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

batch: M106815

AA

080530

(4)

9.0 AN415A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

batch: M107321

AA

080530

(4)

10.0 NAS1149F0463P - cad plated J. alum. Washer

6 slots  
D. 4mm



AN900416



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

batch: M5519

AA

080530

(4)

11.0 NAS1149F0563P Washer



Comment: Qty.: 5.0000 Each(s)/Unit Total: 10.0000 Each(s)

Washer

batch: M108099

AA

080530

(4)

12.0 MS21042L4 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

batch: M107478

AA

080530

(4)

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Seq. #: Machine Or Operation: Description :

13.0 MS21042L5 Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

batch: M107464

080530

(52) 2

08.06.02

14.0 D37861 Sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Sleeve

batch: B39350

080530

(52)

08.06.02

15.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-assemble as per dwg D3782

080530

PTO

16.0 QC5 INSPECT WORK TO CURRENT STEP



ENGINEERING  
APPROVAL

08.05.30

Comment: INSPECT WORK TO CURRENT STEP

17.0 PACKAGING 1 PACKAGING RESOURCE #1



FOR ENGINEERING USE ONLY

Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker on inside of part and Stock

Location: \_\_\_\_\_

18.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.06.02

Job Completion



Change to W/O #00196

W08.06.11

D3772-1 Removed material from ID to  $\phi 1.010''$  ~~to 0~~ on both ends  
to allow for fit on D3772-1 and D3773-041

~~A~~ 080530

D3772-041 mounting holes enlarged to allow fit of D3773-041

~~A~~ 080530

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3772-1	BACK LEG	1
2	D3787-1	FOOT	1
3	D3764-1	BACK LEG FITTING	1
4	D3773-041	HEAD REST ADAPTER ASSY	1
5	AN5-15A	BOLT	1
6	AN5-17A	BOLT	1
7	AN45-15A	EYE BOLT	1
8	AN4-15A	BOLT	2
9	NAS1149F0463P	WASHER	4
10	NAS1149F0563P	WASHER	5
11	MS21042L4	NUT	2
12	MS21042L5	NUT	3
13	D3786-1	SLEEVE	1

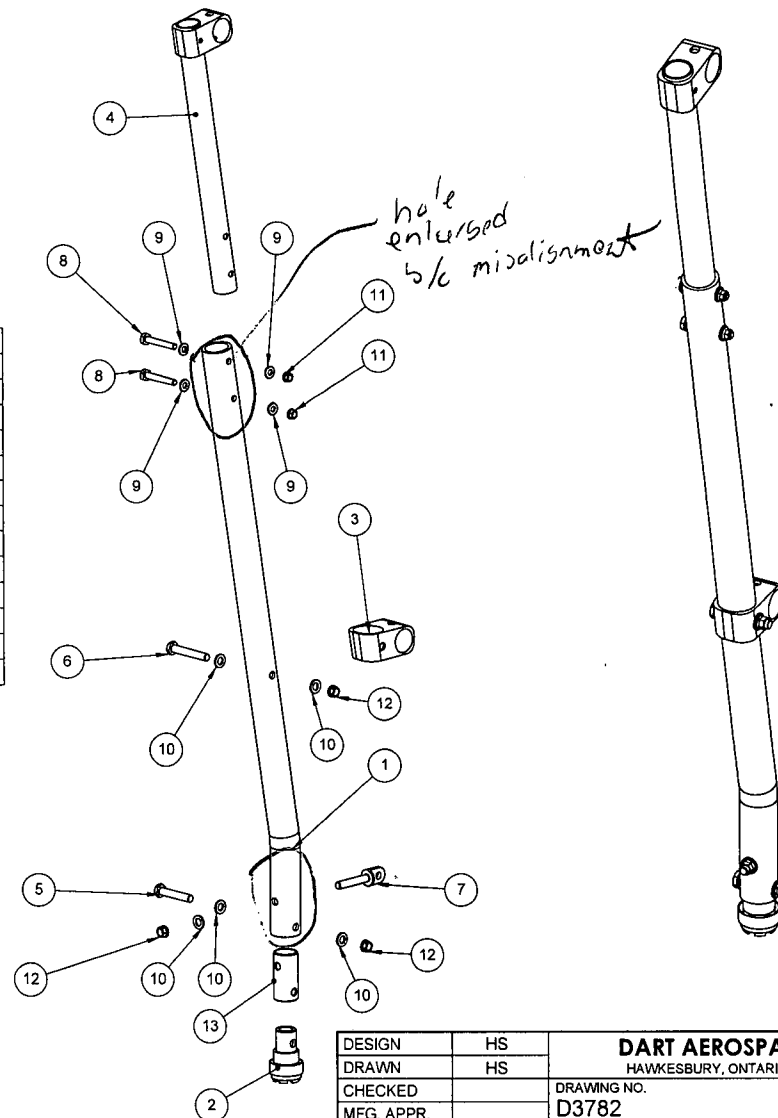
**PROTOTYPE**

*PH 06.05.30*

*QTY x 2* **D3782-045 BACK LEG ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A



DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3782</b>	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>LEG ASSEMBLY</b>	1:1
DATE	08.05.15	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	